

Date: Tuesday, 04/11/2008 8:34:20 AM
 User: Linda Lacelle

Process 5

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : REAR OVERHEAD CENTER
 Job Number : 43181
 Estimate Number : 13591
 P.O. Number :
 This Issue : 04/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R&D THERMOFORMING
 Previous Run : 42073
 Written By :
 Checked & Approved By :
 Comment : Est. A New Issue 08/09/17 DL

Part Number : D38233
 Drawing Number : D38233 UNDER REVIEW 08.11.05
 Project Number : IN0002
 Drawing Revision : A UNDER REVIEW
 Material : MKYDEX6185S80P362015
 Due Date : 14/11/2008 Qty: 2 Um: Each

PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 04/11/2008 Wk

POSITIVE
 RECALL
 CANCEL
 10

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MKYDEX6185S80P362015 Kydex velour matte, ivory



Comment: Qty.: 11.3747 sf(s)/Unit Total : 22.7493 sf(s)
 Kydex velour matte, ivory M109703

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

08/11/05 Wk

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/05 Wk

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-3 and folio (FTA 9110 Prototype) using tool DT 9110

Dwg. Rev. A UNDER REVIEW
 Folio Rev. A.

x2
 08/11/05 Wk

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/05 Wk

Date: Tuesday, 04/11/2008 8:34:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD CENTER

Job Number: 43181

Part Number: D38233

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



08.11.26 (2)



Comment: SECOND CHECK

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

08/11/27 (x2)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.01

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

11.0

QC21

FINAL INSPECTION/W/O RELEASE

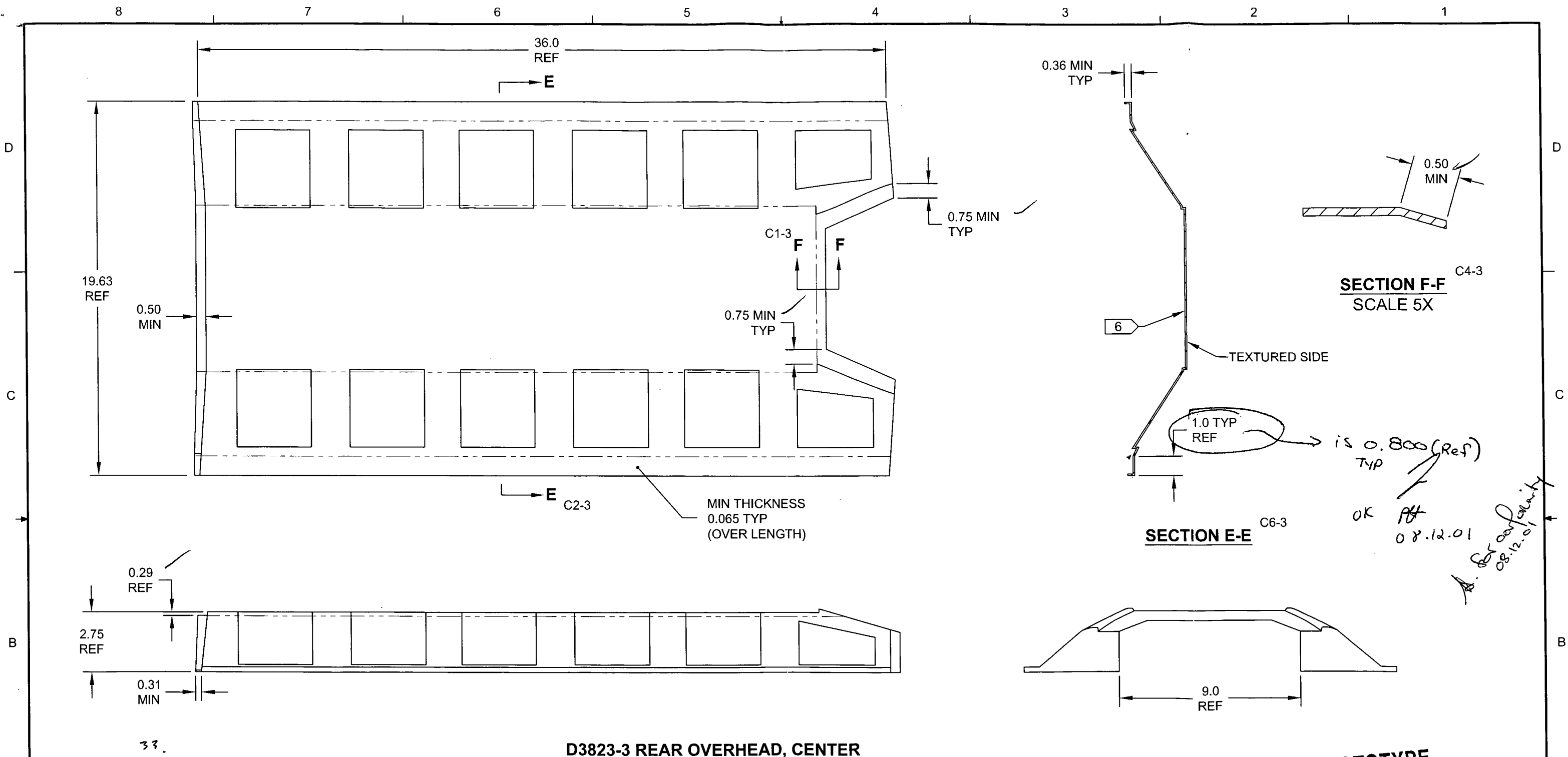


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.12.24 08.12.01 Prototype
POSITIVE RECALL
EFFECTIVE 08.11.04 AUTH 66
RELEASED _____ DATE _____
cancel



NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3823-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.7 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9110 PER DART QSI 022

DESIGN	18	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	18		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3823	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD	NTS
DATE	08.09.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Dates:

Batch No:

Supplier:

Dart P/O:

Packing Slip:

Yes

No

Invoice:

Yes

No

Receipt:

Cash

Cr

Release Note Attached:

Yes

~~No~~

N/A

Waybill Attached:

Yes

No

Shipment Complete

Yes

~~No~~

N/A

QC6 Inspection

Work Order

N/A

N/A

Discrepancies

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Admin:

Location

سابك
sabic

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

59 800/27

08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

DART AEROSPACE LTD		Work Order: 43181
Description: Rear Overhead / Prototype		Part Number: D3823-3
Inspection Dwg: D3823 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: PH Date: 08/11/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.0 (Ref)		36.0	✓			
0.50	± 0.030	0.50	✓			
0.75 min	min.	0.75	✓			
0.75	min	0.77	✓			
0.29 (Ref)		0.293	✓			
0.31	± 0.030	0.32	✓			
0.36	± 0.030	0.37	✓			
1.0 TYP. (Ref)		0.800	✓			Change on dwg. Dim's 800
9.0 (Ref)		8.9	✓			From edge to back.
0.50	Min	0.5	✓			
0.065	min	0.067	✓			

Measured by: PH Date: 08.11.26
Audited by: PH Date: 08.11.26
Prototype Approval: PH Date: 08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	